

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014596**Date Inspected:** 01-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Shi Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

Bay 9, OBG Deck Plate

This QA inspector performed Ultrasonic Testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated UT report for this date. The members are identified as Tower Components. The weld designations reviewed are as follows.

DP3102-001-164, 165, 174, 175

DP3105-001-155, 156, 157, 158

DP3100-001-187, 188, 195, 196

DP3099-001-145, 146, 147, 148

DP3107-001-161, 162, 163, 164

This QA Inspector observed the following work in progress:

BAY 9:

DECK PANEL 13BW-DP3135-001

WELDING INSPECTION REPORT

(Continued Page 2 of 4)

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3135-001; Weld(s) 001 & 009. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3135-001; Weld(s) 003 & 011. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3135-001; Weld(s) 004 & 012. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3135-001; Weld(s) 005 & 013. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3135-001; Weld(s) 006 & 014. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3135-001; Weld(s) 007 & 015. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3135-001; Weld(s) 008 & 016. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3135-001; Weld(s) 001 & 009. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Chen Shi Gang. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

DECK PANEL 13BW-DP3134-001

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 001 & 171. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS

WELDING INSPECTION REPORT

(Continued Page 3 of 4)

used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 002 & 172. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 003 & 173. Welder(s) are identified as 059418. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 004 & 174. Welder(s) are identified as 059421. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 005 & 175. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 006 & 176. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 007 & 177. Welder(s) are identified as 059416. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 008 & 178. Welder(s) are identified as 201788. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 009 & 179. Welder(s) are identified as 203805. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification (WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Gas Metal Arc and Submerged Arc Welding (GMAW/SAW) of DP3134-001; Weld(s) 010 & 180. Welder(s) are identified as 059378. ZPMC Quality Control (QC) is identified as Zhu Zhong Jie. Weld Procedure Specification

WELDING INSPECTION REPORT

(Continued Page 4 of 4)

(WPS) is identified as WPS-B-T-2342-U1(urib)-5. Welding appears to conform to the requirements of the WPS used.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
